August 26, 2009 10:51:45 AM

Item ID:

D2230-1

**Revision ID:** G

Item Name: Lug

**Start Date:** 

8/25/09 Required Date: 9/04/09

Start Qty: 160.00 Req'd Qty: 160.00

09.08.26

Reference:

Approvals:

Process Plan:

QC:

Date:

Date:

Accept

SPC (Y/N):

**Tooling:** 

**Run Hours** 

Date:

Date:

Accept Qty

Reject Qty

Number Stamp

Sequence ID/

**Revision Nbr** 

D2230

Rev G

Bandsaw

Jeaspa Bandsaw

**BAND SAW** 

Memo

Cut D2423 extrusion to 0.82"

0.00

0.00

0.00

0.00

08/08/31

110

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1 Memo

1-Machine per folio D2230-1. (Check for crack while loading into the

machine.): 2-Tumble and deburr rough edges after tumbling

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

Run Start

Setup Start

Stop

Stop

**Work Center ID** Draw Nbr

Operation Description

Set Up/

Draw Number

**Cust Item ID:** 

**Customer:** 

Draw Rev.

Plan Code

Reject

Insp.

160

120

QC

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							:
					+		

Part No: <u>D2230-</u>	PAR #:	Fault Category: Pred. Unch	No DQA:	<u>/</u>	Date: <u>০ ছ ১০ ছ ১ হ</u> ু হ
Resolution: _	SCURP	_ Disposition: _ S Cv Ayo.	QA: N/C Closed:		Date: 05-05-25

NCR:51	566	, <b>W</b> C	JHK OH	DER NON-CONFORMANCI	= (NCR)							
	,	Description of NC		Corrective Action Section B	Verification	Approval	Approval					
DATE ST		STEP	STEP	STEP		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
05-O5-O5	ilO	Proof was moved crooked in the Uise, when the vise was tryhlened and the part hommered in to position. Only 6 parts scrap. Slightly crooked; for thin by 0.005 over tolerance.	osime.	B 45800 Ensue pouts are not ent crooked.	13. A 09/09/09	and 09/09/14	Duys	25-29-05				
		blanks and inally cut positionally	oI.			et.						

August 26, 2009 10:51:45 AM

Item ID:

D2230-1

**Revision ID:** G

Item Name: Lug

Required Date: 9/04/09

**Start Date:** 

8/25/09

Req'd Qty: 160.00



Accept



Run

Setup Start

Stop



**Start Qty: 160.00 Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan:

Date:

**Tooling:** 

Date:

Plan

Code

Start



QC:

Date:

SPC (Y/N):

Draw

Number

Date:

Draw

Rev.

Stop

Reject

Number

Reject

Qty



Insp.

Stamp

Sequence ID/ Work Center ID

130

Quality Control

Operation Description

Memo

Memo

QC8- Inspect parts - second check

Set Up/ **Run Hours** 

0.00

0.00 alogly

160

Qty

Accept

140

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

09/09/15

0.00

150

Quality Control

QC3- Inspect Part Finish

Memo

0.00 BR 09-09-15

									•
W/O:		4,000	WC	ORK ORDER CHANG	BES				*
DATE	STEP	PRO	PROCEDURE CHANGE				Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							:		
Part No	Part No: PAR #:		Fault Cate	gory:	NCR: Yes	No <b>DQ</b>	<b>A</b> :	_ Date: _	
	R	esolution:	Disposition	Disposition: QA: N/0				Date: _	
NCR:			WORK ORD	ER NON-CONFORM	ANCE (NC	R)			
DATE	STEP	Description of NC		Corrective Action Section B		Verifi	fication Approva	Approval	I Approval
	SILI	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Dat		ion C	Chief Eng	QC Inspector
									:
						·			
ı	1	1			1	1		1	1

August 26, 2009 10:51:45 AM

Item ID:

D2230-1

**Revision ID:** G

Item Name: Lug

**Start Date:** 8/25/09

Required Date: 9/04/09

Reg'd Oty: 160.00



Accept



Setup Start

Stop



**Start Qty: 160.00 Cust Item ID:** 

Reference:

**Approvals:** 

**Process Plan:** 

Date:

Tooling:

Date:

**Customer:** 

Draw

Number

Run

Plan

Code

=> Il oglogiano Co

Start Stop



QC:

Date:

SPC (Y/N):

Date:

Draw

Rev.

Reject

Qty

Insp.

Stamp

Reject

Number

Sequence ID/ Work Center ID

160

Powdercoat

Powder Coating

Operation Description

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

1112260

Memo

START TIME: 416

Set Up/ **Run Hours** 

0.00

0.00

OVEN TEMPERATURE:



**Quality Control** 

QC3- Inspect Part Finish

Memo

100 pl 09-09-16.

Accept

Qty

180

Identify as per dwg & Stock Location

0.00

Packaging

Memo

0.00

9/9/12 (1600)5/

Packaging

	•								
W/O:			WO	RK ORDER CHANG	ES			*	
DATE	STEP	PROCEDURE CHANGE				Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
Part No	:	PAR #:	Fault Categ	ory:	NCR: Yes	No DQA:	Date: _		
	Res	olution:	Disposition	:	QA: N/C CI	Closed: Date:			
NCR:				R NON-CONFORMA	NCE (NCR	2)			
DATE	STEP	Description of NC	Description of NC Corrective Action		on B Sign &	Verification		Approval	
		Section A	Initial Chief Eng	Action Description Chief Eng	Date	Section C	Chief Eng	QC Inspector	
İ					1	1	1		

August 26, 2009 10:51:45 AM

Item ID:

D2230-1

**Revision ID:** G

Item Name: Lug

**Start Date:** 

8/25/09

Required Date: 9/04/09

Start Qty: 160.00 Req'd Qty: 160.00

Operation

Description

Reference:

**Approvals:** 

Sequence ID/

**Process Plan:** 

QC:

Memo

Date: Date:

SPC (Y/N):

Set Up/ **Run Hours** 

0.00

0.00

**Tooling:** 

QC21- Final Inspection - Work Order Release

Work Center ID

Quality Control

190

Accept



Setup Start



Stop

**Cust Item ID:** 

**Customer:** 

Date:

Date:

Run Start

Stop

Draw Number Draw Rev.

Plan Code

Accept Qty Qty

Reject Reject

Insp. Number Stamp

09/09/23 H) MF 09-09-13

W/O:			WC	ORK ORDER CHA	NGES				····	, ,
DATE	STEP	PROCEDURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval' QC Inspector
									.,4-14,-1	
									_	
Part No	:	PAR #:	Fault Cate	gory:	NCI	R: Yes	No <b>DQ</b>	<b>A</b> :	_ Date: _	
	R	esolution:	Dispositio	n:	QA:	N/C CI	osed:		Date:	
NCR:	R			n: ER NON-CONFOR					Date:	
NCR:	STEP		WORK ORD	ER NON-CONFOR  Corrective Action  Action Descript	RMANCE Section B	(NCR	Verifi	cation	Date:  Approval Chief Eng	Approval
		Description of NC	WORK ORD	ER NON-CONFOR	RMANCE Section B	(NCR	Verifi	cation	Approval	
		Description of NC	WORK ORD	ER NON-CONFOR  Corrective Action  Action Descript	RMANCE Section B	(NCR	Verifi	cation	Approval	Approval
		Description of NC	WORK ORD	ER NON-CONFOR  Corrective Action  Action Descript	RMANCE Section B	(NCR	Verifi	cation	Approval	Approval

## **Picklist Print**

August 26, 2009 10:51:44 AM

Work Order ID: 51566

Parent Item:

D2230-1RevG

Parent Item Name: Lug

Comments:

Component Item ID/	Replacement	Mfg/
Item Name	Item ID	Purch

D2230-1PRevF

Purchased

Manufactured



LUG

D2423RevB1

Lug Extrusion



**Start Date: 8/25/09** 

Required Date: 9/04/09

Status

Date

Issued

Start Qty: 160.00 Required Qty: 160.00

Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued
No	^		100 09-09-	Each	0.0000	160.0000	
No "		H mil	110	f	724.9297	11.5032	

Warehouse	Loc Qty	Loc Code	
<b>Location</b>			
Main Warehouse			
ST	724.92968		
43722	213.01468		
44529	22.39		
45800	489.525		11.48

	Copaco								
W/O:			WC	ORK ORDER CHANG	GES				· · · · ·
DATE	STEP	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
-									
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DC	A:	Date: _	
	Re	esolution:	Dispositio	n:	QA: N/C	Closed:		Date: _	
NCR:		,	WORK ORD	ER NON-CONFORM	ANCE (NC	R)			
DATE	STEP	Description of NC	Description of NC Corrective Actio			——— Verific			Approval
	JILI	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Dat		tion C	Approval Chief Eng	QC Inspector

DART AEROSPACE LTD	Work Order:	51566
Description: Mounting Lug	Part Number:	D2230-1
Inspection Dwg: D2230 Rev: F		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

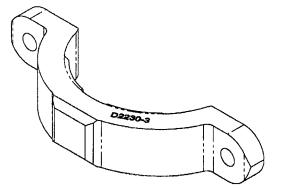
Drawing	Toloronos	Actual	Accept	Daisat	Method of	Comments
Dimension	Tolerance	Dimension	Accept	Reject	Inspection	Comments
4.450	+/-0.010	4.1152				
0.306	+/-0.010	.307				
0.345	+/-0.010	,340				
0.400	+/-0.010	.398				
0.250	+/-0.010	251				
3.700	+/-0.010	3.697				
0.750	+/-0.010	,751				
Ø0.257	+0.005/-0.000	87£. 🛪				
1.91	+/-0.010	1.9/3				
R1.200	+/-0.010	R 1.200		·		
0.375	+/-0.010	376				
-						

Measured by: MW	Audited by:	Prototype Approval:	N/A
Date: 8/09/03	Date: 09/04/14	Date:	

Rev	Date	Change	Revised by	Approved
Α	03.11.11	New Issue	KJ/RF	- 4

D2230-1

**D2230-1 MOUNTING LUG** 



**D2230-3 MOUNTING LUG** 



DESIGN BW DART AEROSPACE LTD				TD
REV.	DESCRIPTION		8Y	DATE
С	RE-DESIGN	BW	94.03.30	
D	RE-DESIGN		BW	95.01.04
Ε	RE-DESIGN		BW	95.01.04
F	REDESIGN; R1.200 WAS 1.100			99.12.13
G	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A & B-B FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION.			09.01.16

REV.		DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD		ľD
DRAWN	AJIS	HAWKESBURY, ONTA		
CHECKED	51	DRAWING NO.		REV. G
MFG. APPR.	Cont.	D2230		SHEET 1 OF 3
APPROVED	M	TITLE		SCALE
DE APPR.	-4	MOUNTINGLUG		NTS
DATE 09.01.16		THE DOCUMENT IS PROVIDED FOR 1994 BY DART AEROSPACE LTD  THE DOCUMENT IS PROVIDED FOR THE PROPERTY OF THE EXPRESS CONSISTION THAT IT IS  NOT TO BE USED FOR MY PLANFORS ON COMES OF COMMENCENTED TO ANY OWNER PLANFORM WITHOUT  THE PROPERTY OF THE PROPERTY OF THE PROPERTY OF THE PLANFORM WITHOUT  THE PROPERTY OF THE PROPERTY OF THE PLANFORM WITHOUT  THE PROPERTY OF THE PLANFORM OF THE PLANFORM WITHOUT  THE PROPERTY OF THE PLANFORM OF THE PLANFORM WITHOUT  THE PROPERTY OF THE PLANFORM OF THE PL		

D

С

NOTES:
1) MATERIAL: MAKE FROM D2423 EXTRUSION
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ±0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015±0.005.
7) WEIGHT: -1: 0.16 lbs
-3: 0.14 lbs

D

